Work Order ID 73297

Wednesday, August 31, 2011 10:45:23 AM

Item ID: D2585 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Mounting Channel

Start Date: 9/1/2011 **Start Qty:** 30.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 30.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2585	Rev B								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B11-9-17			
FLOW CNC Waterjet	1-Cut as per Dwg D2585								
304 . 025	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
									(55)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-9-12			
Quality Control									
120	QC8- Inspect parts - second check	0.00				counted			
QC	**Memo**	0.00				(55)			
Quality Control									

5 w/o 9/12

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73297

Wednesday, August 31, 2011 10:45:23 AM

Item ID: D2585 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Mounting Channel

Start Date: 9/1/2011 **Start Qty:** 30.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 30.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Deburr if necessary	N/A							
140	NC BRAKE	0.00				55			
Brake NC	**Memo**	0.00 SB 11/09/15							
Brake NC	Form as per Dwg D2585								
150	QC5- Inspect part completeness to step on W/O	0.00				county XXX			
QC	**Memo**	0.00 S 11/09/15							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73297

Wednesday, August 31, 2011 10:45:23 AM

Item ID: D2585 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Mounting Channel

Start Date: 9/1/2011 **Start Qty:** 30.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 30.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location OM	0.00							
Packaging	**Memo**	0.00					11/9/16		JS
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00					11/9/16		
Quality Control									

MK
11-09-16

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:45:20 AM

Work Order ID: 73297

Parent Item: D2585

Parent Item Name: Mounting Channel

Start Date: 9/1/2011 **Required Date:** 9/15/2011

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP D□04.02.16□Reformat; Add Receiving Step□KJ/RF□
IPP C 06.07.21 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	48.7000	0.0157	0.495789	1,		
304SS sheet .080											8-11-9-17		

Location	Loc Qty	Loc Code
MAT020	48.7	
113295	16.7	
117933	32	

113295

(55)

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Mounting Channel	Part Number:	D2585
Inspection Dwg: D2585 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.590	+/-0.010	2.596	✓		V BO7	
0.875	+/-0.010	.881	✓		V	
0.078	+/-0.010	.073	✓		V	
Ø0.191	+0.005/-0.001	.193	✓		V	

Measured by:	B	Audited by:	D	Prototype Approval:	N/A
Date:	11-9-12	Date:	11/09/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

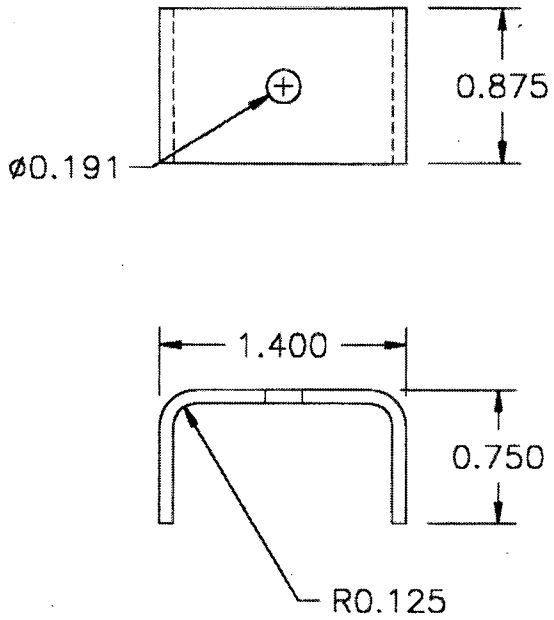
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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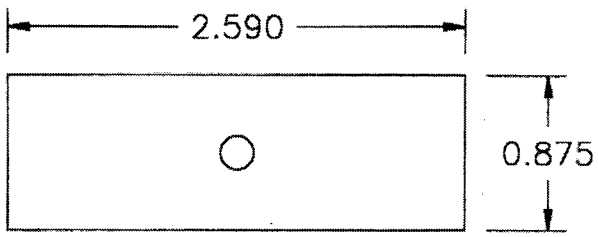
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
BW			
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	BW	D2585	SHEET 1 OF 1
DATE		TITLE	SCALE
96:07:11		MOUNTING CHANNEL	1:1
B	97:03:14	ADD FLAT PATTERN	

DA COPY ISSUED

RELEASED
97/03/14 DS



FLAT PATTERN



MATERIAL: 304/316 SS, 14 GAUGE (0.078)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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